

Date: Tuesday, 4/24/2007 3:19:20 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER INLET ADAPTER
Job Number	: 32040		
Estimate Number	: 12318		
P.O. Number	: <i>N/A</i>	Part Number	: D3473043
This Issue	: 4/24/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3473 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 28560	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 5/8/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	2 Um: Each
Comment	: est rev. A 06.03.02 new issue EC Est Rev:B As per Rev B 06-05-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34735	VERTICAL TUBE
-----	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3473-5	tube	<i>B28807</i>

2.0	D34733	COVER
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
<i>X</i> 1	D3473-3	Cover	<i>B 32050</i>

3.0	D34739	FLANGE
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
<i>X</i> 1	D3473-9	Flange	<i>B28589 B 26121</i>

4.0	D34731	DUCT
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
<i>X</i> 1	D3473-1	Duct	<i>B 32049</i>

MF 07-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/24/2007 3:19:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 32040

Part Number: D3473043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34737

HORIZONTAL TUBE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D3473-7	Tube	B27020 -

6.0

AN960C416L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
2	AN960C416L	washer	m103641 -

7.0

NAS1031C3W

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
6	NAS1031C3W	Nutplate	m101144 -

mf 07-05-01

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole as per dwg D3473

2-Spot weld as per dwg D3473

mf 07-05-01

9.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/05/01

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1



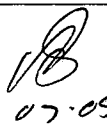

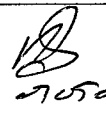
Identify and Stock

Location: G.A.

mf 07-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/05/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/02	8	Seams on D3473-7 and D3473-5 are opposite to dug		Acceptable	 07-05-02	 07-05-02		 07-05-02

NOTE: Date & initial all entries

Date: Tuesday, 4/24/2007 3:19:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER INLET ADAPTER

Job Number: 32040

Part Number: D3473043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/02

Job Completion



U 07-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

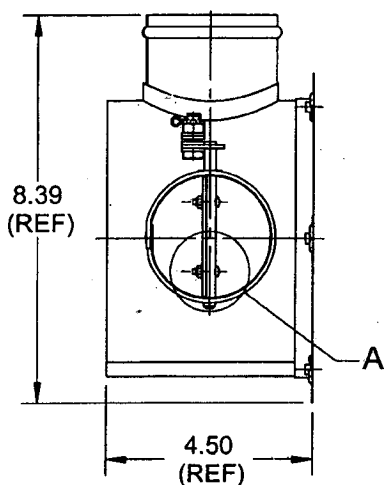
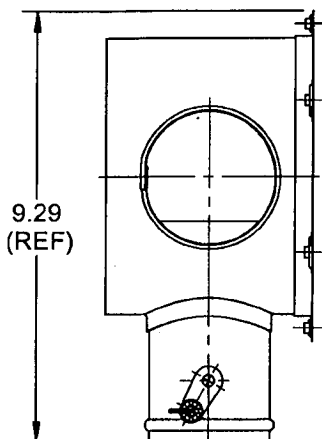
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

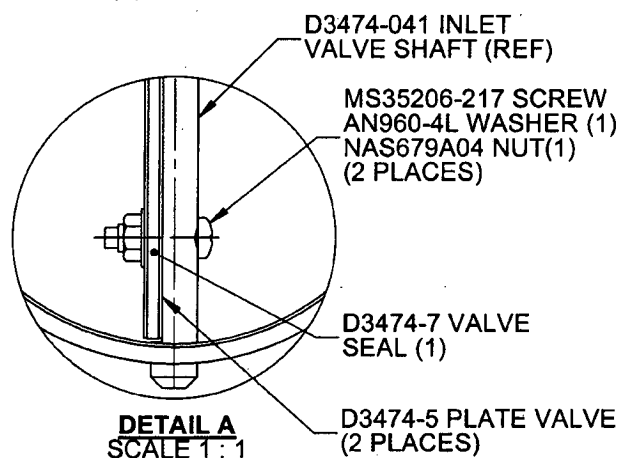
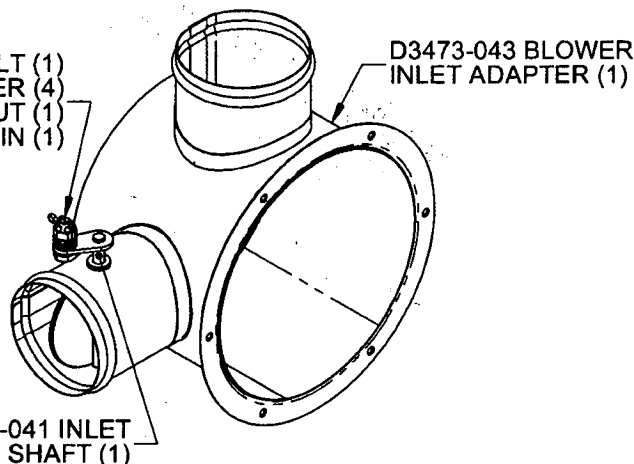


RELEASED
06-05-16

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3473	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4
A	06.02.07	NEW ISSUE	
B	06.05.16	D3473-5F/-7F: 9.750 & 8.810 WERE 9.60 & 8.60	



D3470-9 BOLT (1)
AN960-416 WASHER (4)
AN310-4 NUT (1)
MS24665-153 COTTER PIN (1)



D3473-041 BLOWER INLET ADAPTER

NOTES:

- 1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

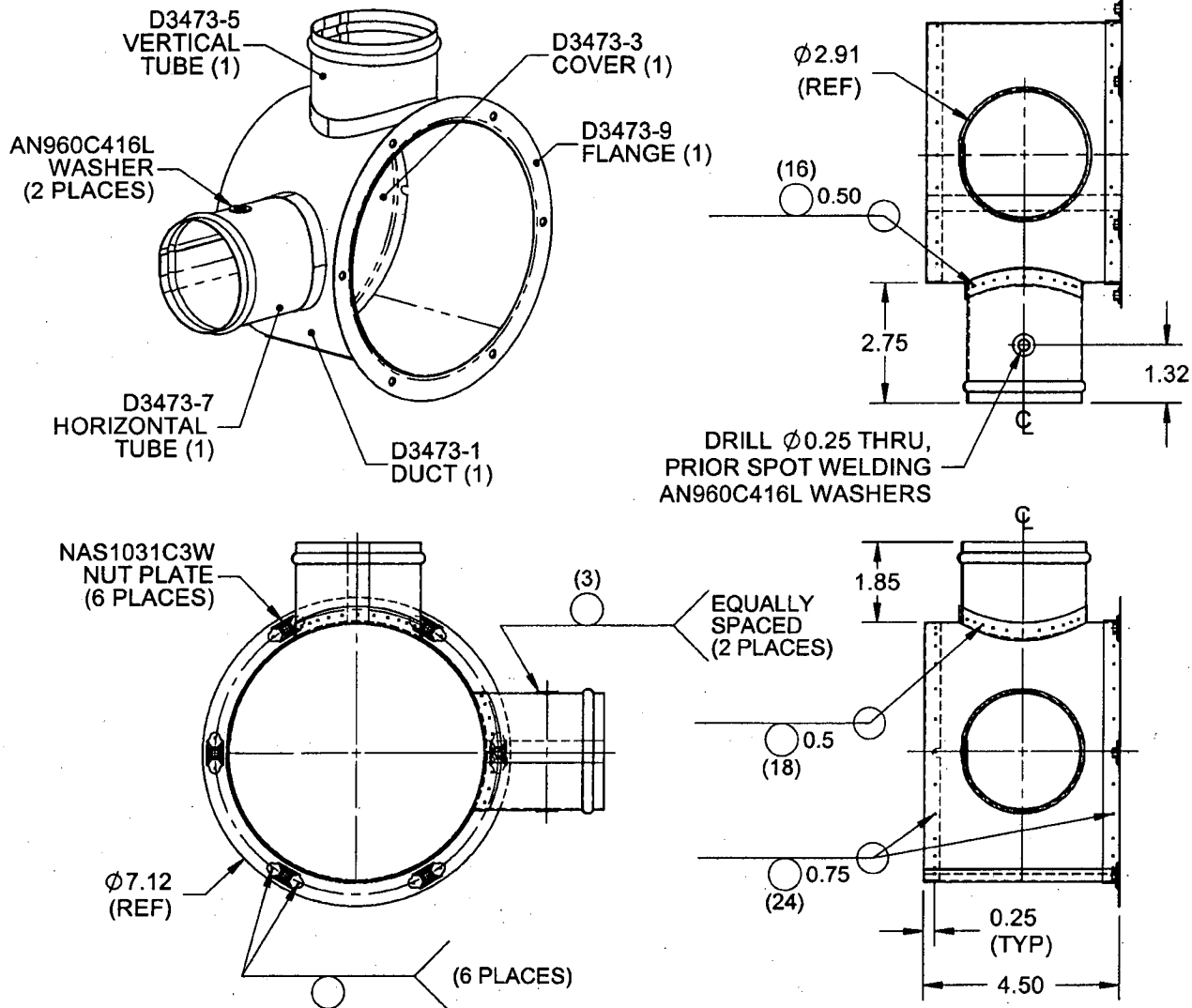
QTY -041	P/N	DESCRIPTION
X	D3473-041	BLOWER INLET ADAPTER
1	D3470-9	BOLT
1	D3471-043	BLOWER INLET WELDMENT
1	D3474-041	INLET VALVE SHAFT
2	D3474-5	BUTTERFLY VALVE
1	D3474-7	BUTTERFLY VALVE SEAL
1	AN310-4	NUT
2	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
2	MS35206-217	SCREW
2	NAS679-A04	NUT

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CHECKED H	APPROVED H	DRAWING NO. D3473	REV. B SHEET 2 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4

RELEASED
06.05.16 H**D3473-043 BLOWER INLET WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

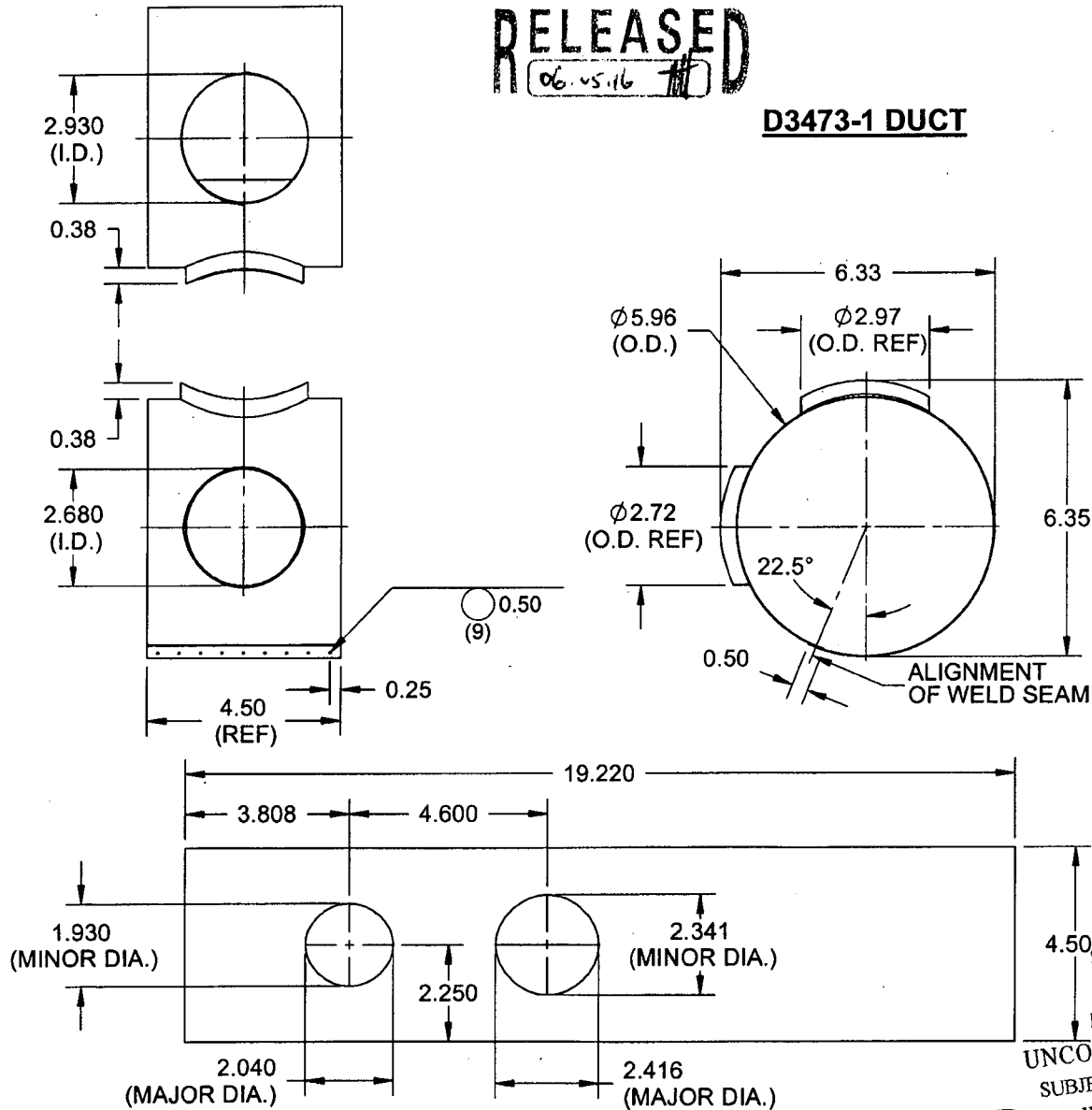
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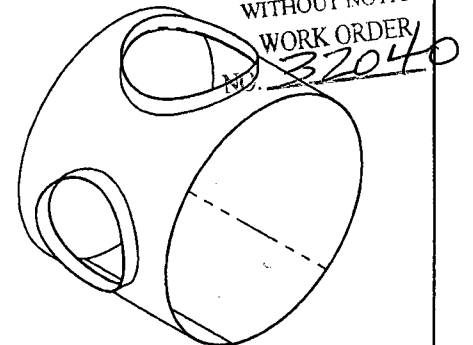
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3473	REV. B SHEET 3 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4

RELEASED
*06.05.16***D3473-1 DUCT****D3473-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

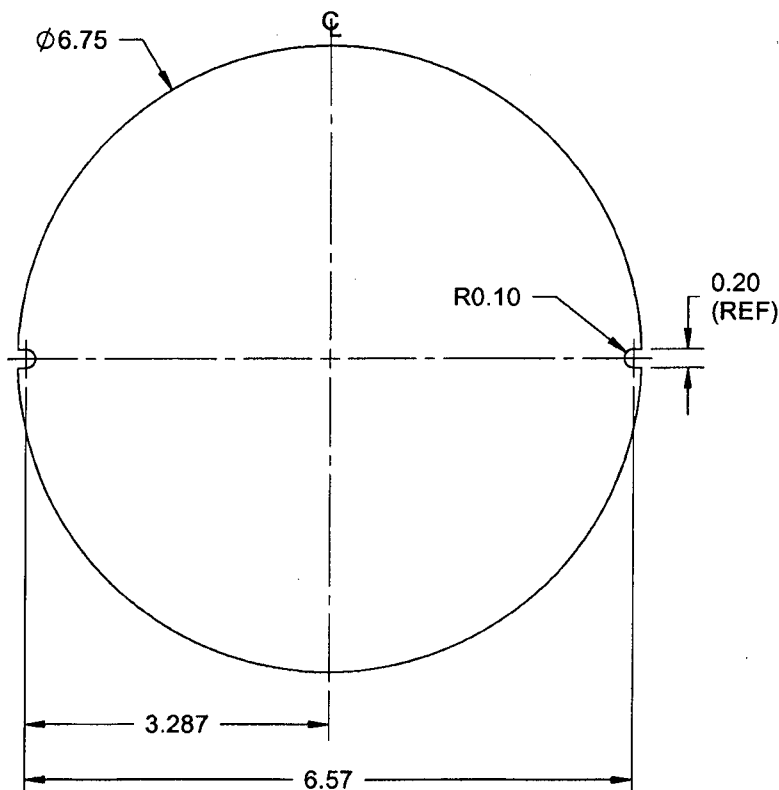
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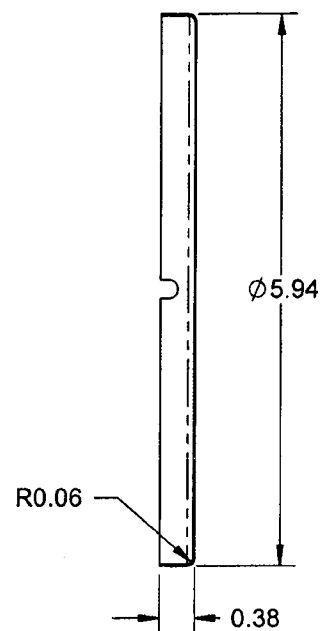


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3473	REV. B SHEET 4 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
06-05-16 *[Signature]*



D3473-3F COVER FLAT PATTERN



D3473-3 COVER

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

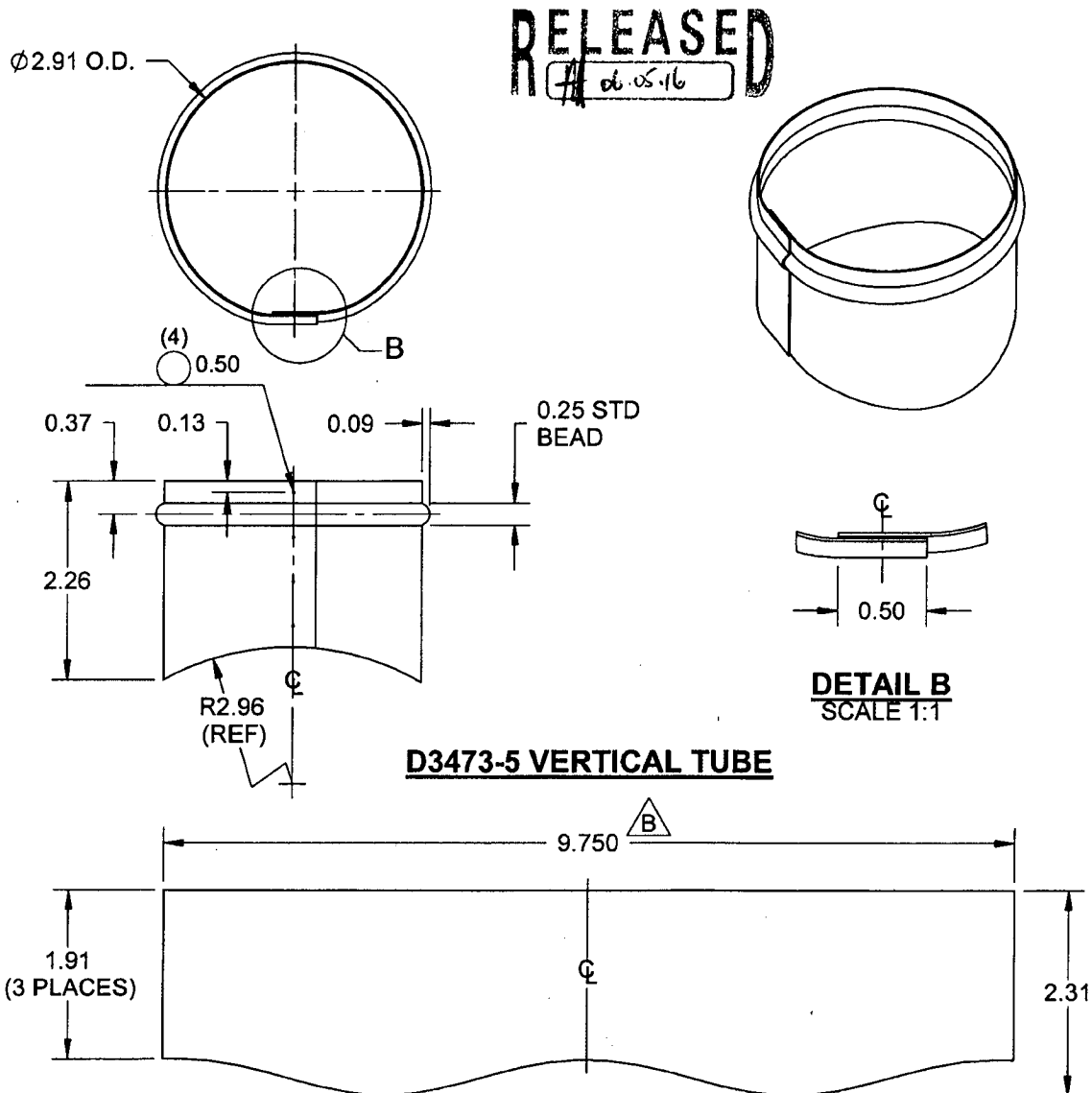
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

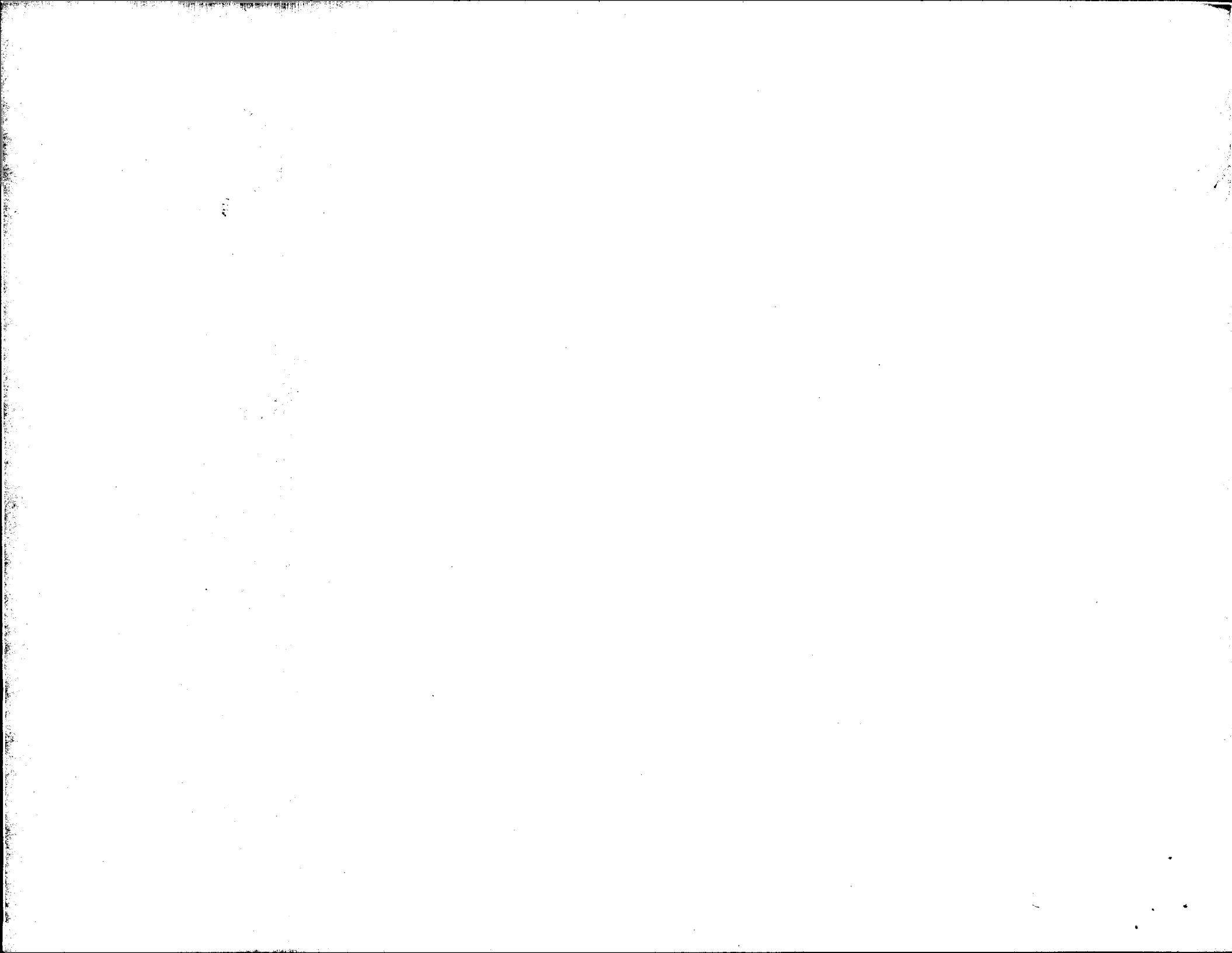
**D3473-5F VERTICAL TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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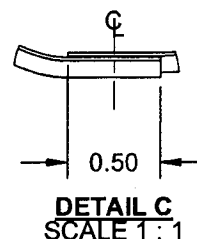
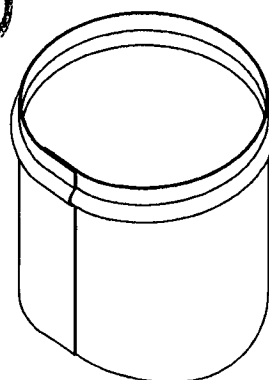
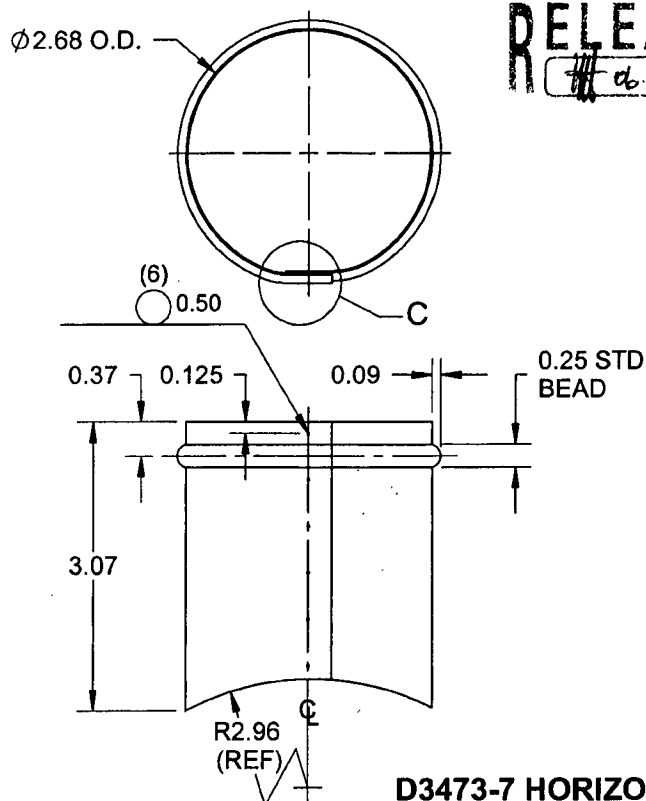
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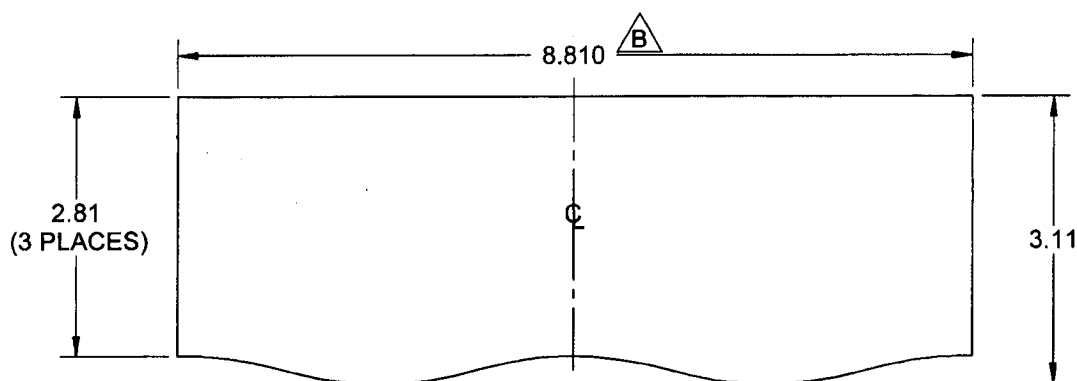


DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AA</i>	APPROVED <i>AA</i>	DRAWING NO. D3473	REV. B SHEET 6 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
06.05.16



D3473-7 HORIZONTAL TUBE



D3473-7F HORIZONTAL TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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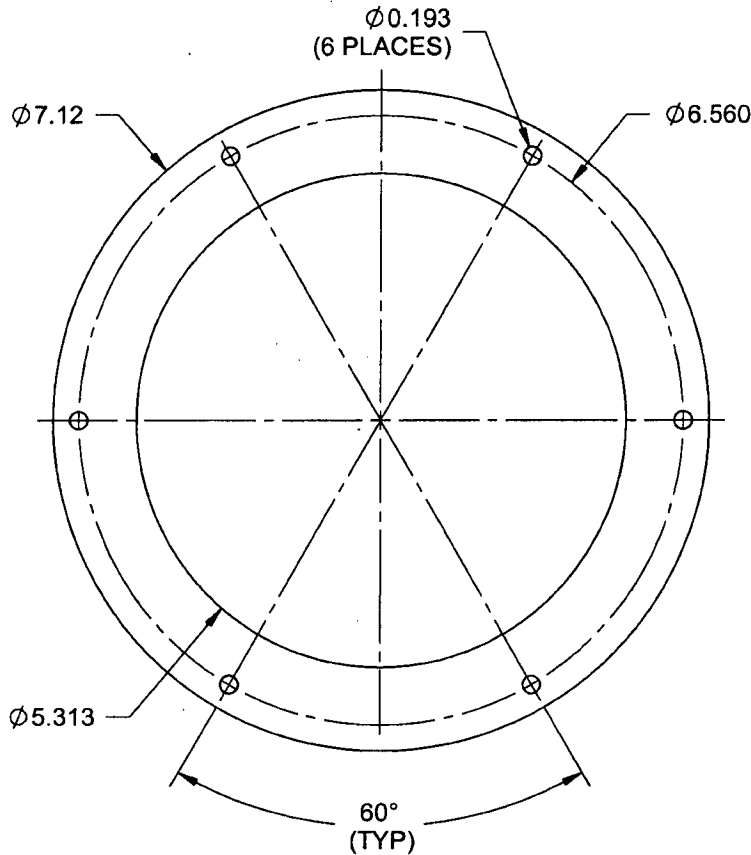
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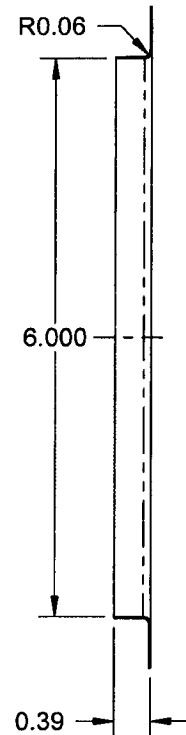


DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3473	REV. B SHEET 7 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED
#06.05.16



D3473-9F FLANGE FLAT PATTERN



**D3473-9 FLANGE
BENDING DETAIL**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO: 6

EMPLOYEE: Melanie Faurey

PART NUMBER: D3473-043

JOB NUMBER: B 32040

MATERIAL TYPE: 304 SS

MATERIAL THICKNESS: 26 G

GROUP SPECIFICATION: _____

Group 1: Aluminum & magnesium

Group 2: Iron; nickel; cobalt

Group 3: Titanium

TEST RESULTS

PASS FAIL

VISUAL:

☒ ☒ ☒ ☒

PENETRATION:

☒ ☒ ☒ ☒

PULL STRENGTH:

☒ ☒ ☒ ☒

PSI Reading: _____

The individual named above has been trained and is qualified in accordance with standard AMS-W-6858A. and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/05/01

QUALIFIER: SB